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D4037-3

Job Sheet 202898



Part No: D4037-3

Job Qty: 4 pcs

Part Name: Fwd Crossbeam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Due Date: 12/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP REV:B AS PER REV B 10-04-19
JLM VERIFIED BY:EC IPP REV:D AS PER ECN 11-554 11-05-24 JLM VERIFIED BY:DD IPP REV C:AS PER
ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		12/12/19	0.17	4.21	Waterjet - Flow		OK 19/11/30
110	HAAS 4 Axis - B4B	4 pcs		12/12/19	1.00	11.43	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		mm. 20/01/05
120	QC 2	4 pcs		12/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		

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				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	mm. 20/01/05
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	4	12/12/19	0.00 0.00	QC 8 - 12	
pcs				QC 8 - 14	mm. 20/01/06
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical- B4B	4	12/12/19	0.00 0.84	Handfinish - 1 - 1 - B4B	
pcs				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JAN 09 2020
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	

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					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	4 pcs	12/12/19	0.00 0.86	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	4 pcs	12/12/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	4 pcs ✓	12/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 -	

M235370.

START 8:35 OUT 3:30 FINISH 9:05

B4 20-01-B.

DAS
81
9-89

JAN 13 2020

ST 635

DAS
80
9-89

JAN 14 2020

DAS
82
9-89

				B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 ✓ pcs	12/12/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 635
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-00
Part Op 100 - Cut blank as per file D4037-3_BLANK Descriptions: 110 - HAAS CNC Vertical Machine) MACHINE AS PER FOLI FA878 AND DWG 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					

JAN 14 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X16.000	6061-T6 Bar 1.00 X 16.00	15.6000 ft (3.9 ea)	100-Waterjet - Flow - 1	5232778
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6B1.000X16.000	16	8	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD	Work Order:	7012 898
Description: Fwd Crossbeam	Part Number:	D4037-3
Inspection Dwg: D4037 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
41.66	+/-0.030	41.650	✓		tape	(ref)
0.92	+/-0.030	.919	✓		vernier	B17321453
1.75	+/-0.030	1.749	✓		vernier	B17321453
0.92	+/-0.030	.917	✓		vernier	B17321453
2.125	+/-0.010	2.123	✓		vernier	B17321453
Ø0.316	+0.006/-0.001	.316 d	✓		Pin gauge	(ref)
Ø0.391	+0.006/-0.001	.3907	✓		Pin gauge	(ref)
0.28	+/-0.030	.281	✓		vernier	B17321453
R0.19	+/-0.030	R.190 ok	✓		Gebnit	(ref)
0.63	+/-0.030	.625	✓		vernier	B17321453
1.50	+/-0.030	1.498	✓		vernier	B17321453
1.20	+/-0.030	1.200	✓		vernier	B17321453
1.95	+/-0.030	1.965	✓		vernier	B17321453
6.00	+/-0.030	5.990	✓		vernier	B17321453
10.54	+/-0.030	10.540	✓		vernier 12"	CNC-02
1.38	+/-0.030	1.374	✓		vernier	B17321453
1.75	+/-0.030	1.749	✓		vernier	B17321453
7.79	+/-0.030	7.788	✓		high gauge	31006
5.80	+/-0.030	5.800	✓		high gauge	31006
2.250	+/-0.010	2.247	✓		vernier	B17321453
0.875	+/-0.010	.873	✓		vernier	B17321453
6.000	+/-0.010	5.999	✓		vernier	B17321453
7.75	+/-0.030	7.752	✓		vernier	B17321453
1.125	+/-0.010	1.123	✓		vernier	B17321453
9.29	+/-0.030	9.288	✓		vernier 12"	CNC-02
5.17	+/-0.030	5.17	✓		vernier	B17321453
10.79	+/-0.030	10.790	✓		high gauge	31006
0.91	+/-0.030	.925	✓		vernier	B17321453
0.09 x 45°	+/-0.030 x +/-0.5°	.090 x 45°	✓		vernier	B17321453
0.31	+/-0.030	.320	✓		vernier	B17321453
0.25	+/-0.030	.250	✓		micrometer	67173765
0.530	+/-0.010	.522	✓		Pin gauge	(ref)
0.25	+/-0.030	.250	✓		micrometer	67173765
0.550	+/-0.010	.551	✓		high gauge	31006
3.00	+/-0.030	3.001	✓		vernier	B17321453
2.00	+/-0.030	2.00	✓		size telescope	
1.00	+/-0.030	1.017	✓		vernier	B17321453

1.435
1.005

1.340

761

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____			
		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			